

6061 43125 x.058w

Work Order ID 132711***132711***

Page 1

Thursday, May 07, 2015 2:56:11 PM

Item ID: D3681-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Spacer

Start Date: 5/7/2015

Start Qty: 20.00

20

Cust Item ID:

Required Date: 5/7/2015

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

CL

Date: MAR 08 2015

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3681

Rev A

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA711& DWG D3681

FOLIO REV: NADWG REV: A

2-DEBURR AS REQUIRED

20

SL562

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

20

SL562

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

20

0

DAS
14
9-89

15/06/02

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval			
Description Work Order Deviation				Disposition				Completed By			
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : _____											

Work Order ID 132711

Thursday, May 07, 2015 2:56:11 PM

132711

Page 2

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Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Spacer

Start Date: 5/7/2015

Start Qty: 20.00

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Cust Item ID:

Required Date: 5/7/2015

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

125

0.00

125

Skidtubes

Memo

0.00

Skidtubes

1- clean crossbolt spacer with ultra brigh aluminum cleaner before storing.

20 0 BE 15-06-03

130

Identify as per dwg & Stock Location: LG001

0.00

130

Packaging

Memo

0.00

Packaging

STOCK IN SKIDTUBE CELL
LOCATION : LG001

20 0 BE 15-06-03

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCJ JUN 03 2015

h 15-06-03

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Thursday, May 07, 2015 2:56:11 PM

Page 1

Work Order ID: 132711

132711

Parent Item: D3681-1

D3681-1

Parent Item Name: Spacer

Start Date: 5/7/2015

Required Date: 5/7/2015

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev A new issue 07-10-30 DD verified by:EC
IPP Rev:B Ecn 1056 Rev A dwg DD IPP Rev:C add
seq 125 DD 10.05.03 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.3125W.05 8		Purchased		No		100	f	93.0000	0.34	8			

M6061T6T0.3125W.058

ALUM TUBE .3125 x .058w

SL15-62

Location

Loc Qty

Loc Code

MAT013

93

m128855

93

*6.0

DQA: _____ Date: _____

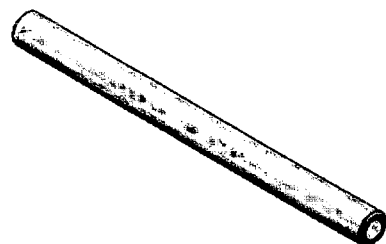


WORK ORDER NON-CONFORMANCE / UPDATE

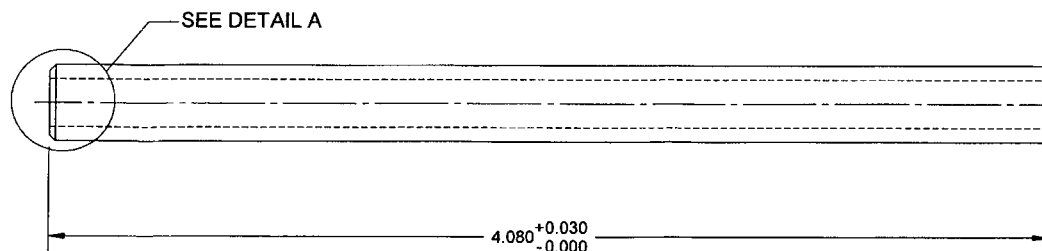
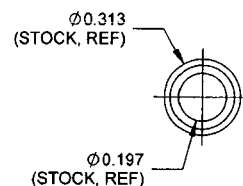
QA Closed: _____ Date: _____

Work Order update only ☐

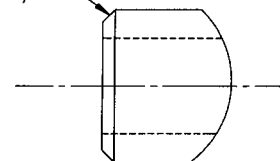
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D3681-1 SPACER



0.025 X 45°
CHAMFER
(TYP)



DETAIL A
(SCALE 4 : 1)

CL MAR 08 2005
W/O: 132711

RELEASED
07-11-09

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T0.313W.058)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

A		NEW ISSUE		DC	07.11.08
REV.	DESCRIPTION			BY	DATE
DESIGN	DC	DART AEROSPACE USA, INC. PORT HADLOCK, WA			
DRAWN	SC				
CHECKED	MD	DRAWING NO.	REV.		
MFG. APPR.	EP	D3681	SHEET 1 OF 1		
APPROVED	W	TITLE	SCALE		
DE APPR.	W	SPACER	2.		
DATE	07.11.08				
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